

Work Order ID 54947

January 5, 2010 10:17:45 AM



Page 1

Item ID: D3186-4

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacepod Door, RH

Start Date: 03/01/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 03/01/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: *RL*

Date: *10-1-05*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3186

Rev E

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Drill holes and cut out slots for latch as per dwg D3186 (D3186-4 detail)

RT 10-02-23

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sublet 23

(H)

120

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

composites

RT 10-02-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54947

January 5, 2010 10:17:45 AM



Page 2

Item ID: D3186-4

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacepod Door, RH

Start Date: 05/01/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 8/01/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/24

MF
10-2-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:17:50 AM

Page 1

Work Order ID: 54947

Parent Item: D3186-4

Parent Item Name: Spacepod Door, RH


Start Date: 05/01/2010

Required Date: 18/01/2010

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3186-2M		Manufactured	No			100	Each	1.0000	1.0000			
												
SPACEPOD DOOR RH												

85 10-02-22

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

CA

1

53191

1

353192

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

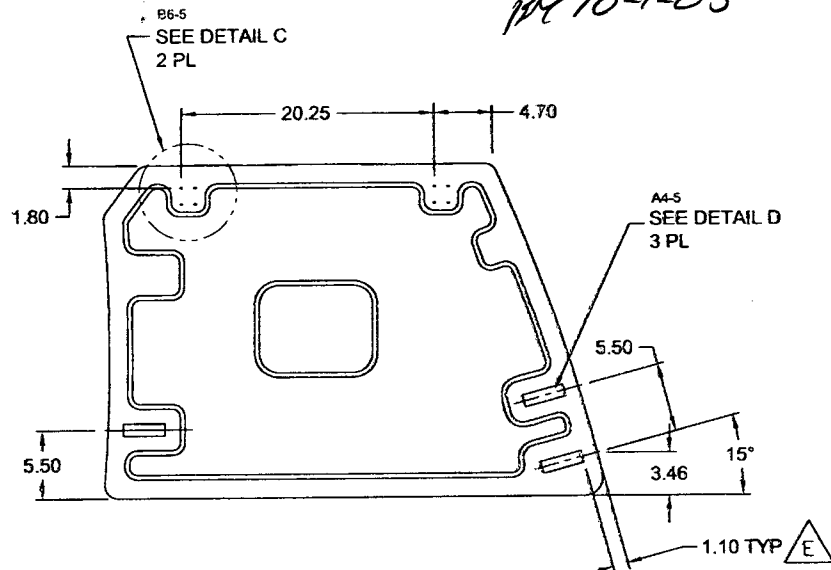
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NOTE: Date & initial all entries

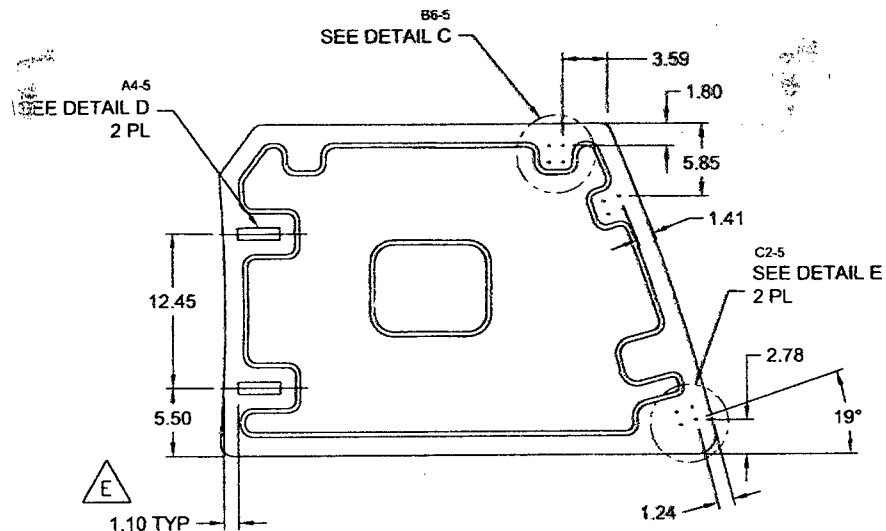
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMEND
WITHOUT NOTICE
WORK ORDER
NO. 54947
PM/10-1-05



D3186-1 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A



D3186-3 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

RELEASED
2009-09-09

REV.	DESCRIPTION	BY	DATE
E	DRAWING UPDATED TO CURRENT STANDARDS. 1.10 WAS 0.98 (ZN B5-1, B4-1, B7-2, B1-2); R0.12 WAS 0.125 (ZN B5-5); REF PAR 09-026	RF	09.07.08
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN. UPDATED D3186-1M-2M-3/4 ADDED	LE	06.09.25
A	NEW ISSUE	CP	03.03.27
DESIGN	DS	DART AEROSPACE LTD KAWKESBURY, ONTARIO, CANADA DRAWING NO. D3186 TITLE SPACEPOD DOOR SCALE NTS COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DATE	09.07.08	REV. E SHEET 1 OF 5	

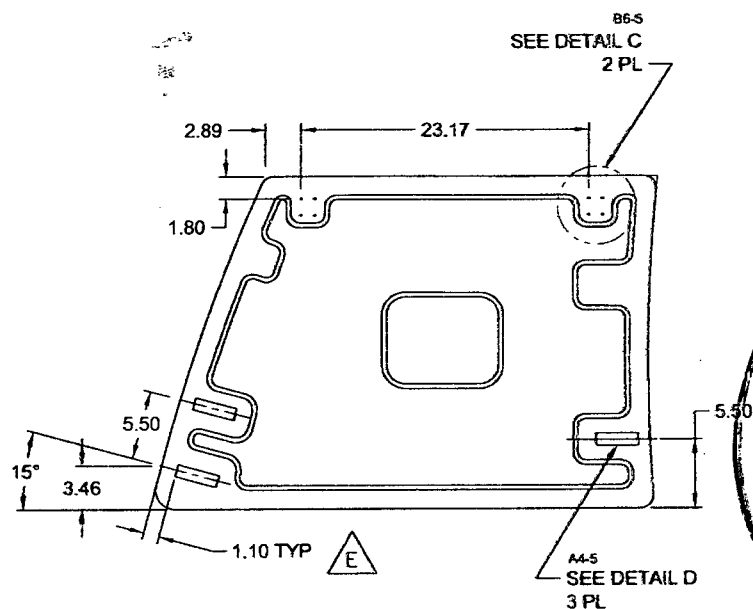
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

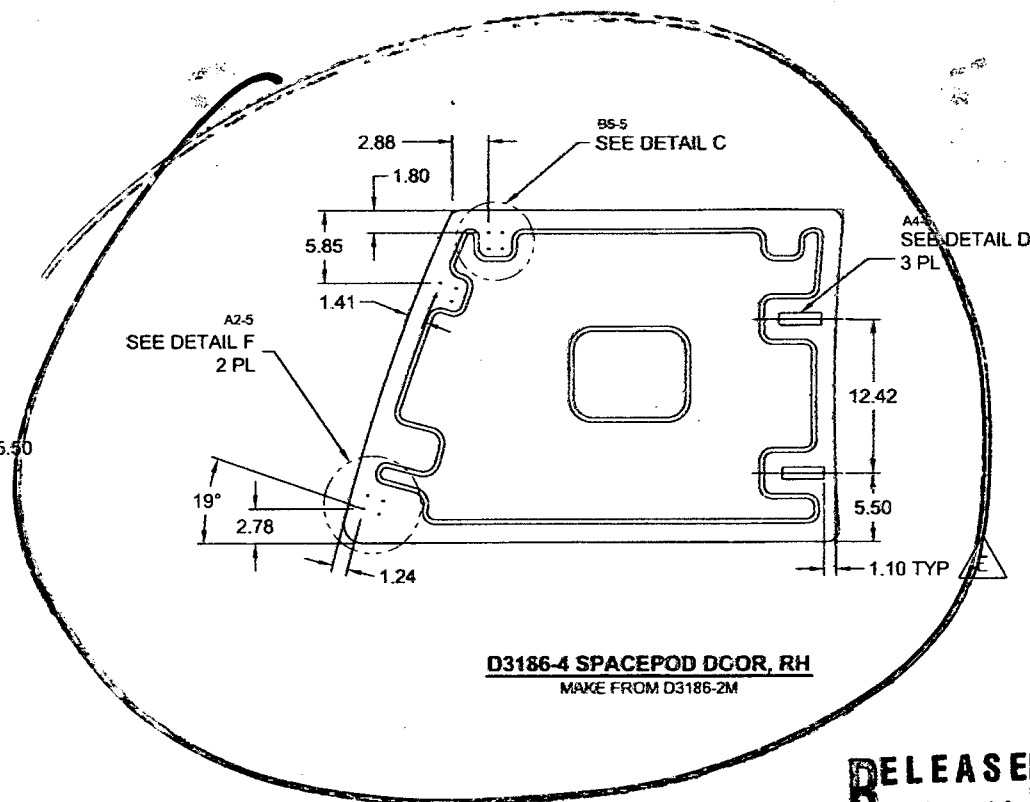
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3186-2 SPACEPOD DOOR, RH
MAKE FROM D3186-2M



D3186-4 SPACEPOD DOOR, RH
MAKE FROM D3186-2M

RELEASED
2008-09-09

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	MD	D3186	SHEET 2 OF 5
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W/0 54947

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NOTE: Date & initial all entries

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)

9 OZ SATIN (9 SQ FEET)

FOAM

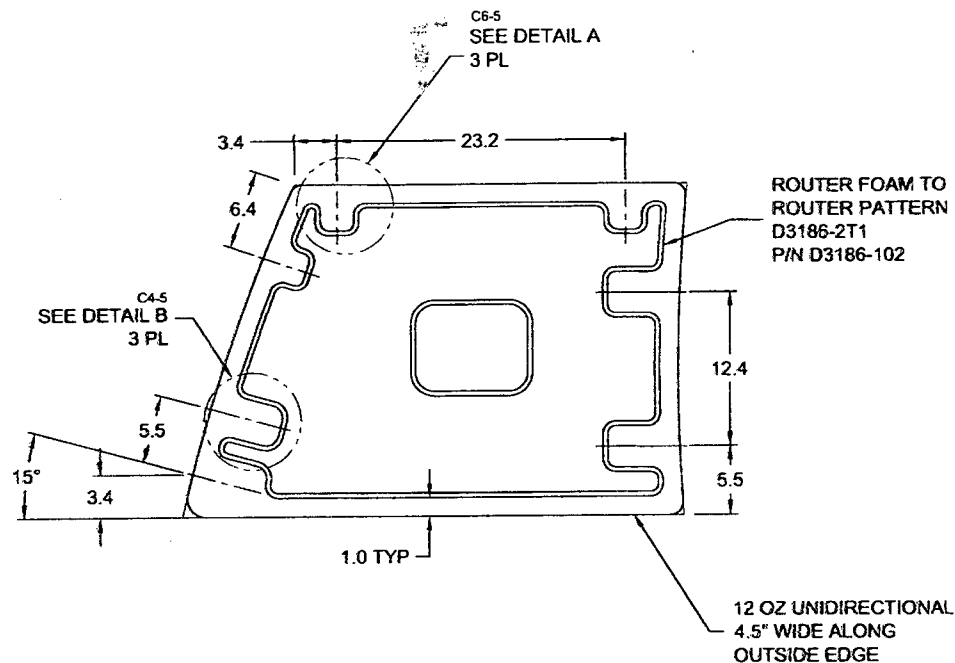
9 OZ SATIN (9 SQ FEET)

12 OZ UNIDIRECTIONAL

9 OZ SATIN (9 SQ FEET)

RESIN (35-45% BY WEIGHT)

PEEL PLY



D3186-2M SPACEPOD DOOR AS MOLDED

NOTES:

1) MATERIAL:

RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FOAM = 3/8" A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL

FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")

12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")

LAMINATE PER DART QSI 006 4.0

LAMINATION SCHEDULE PER THIS DRAWING

2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 7.0 lbs

8) USE MOLD DT8006 FOR DOOR LAYUP

RELEASED
2009-08-09

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED	RF	DRAWING NO. D3186	REV. E SHEET 4 OF 5
MFG. APPR.	RF	TITLE SPACEPOD DOOR	SCALE NTS
APPROVED	RF	DATE 09.07.08	
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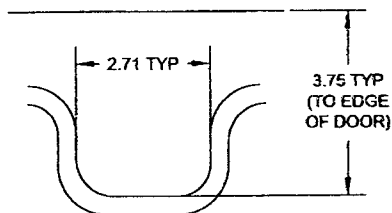
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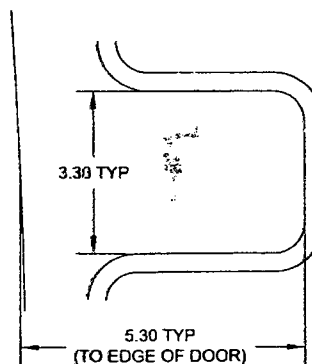
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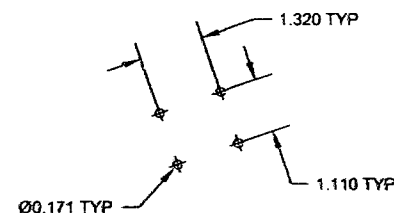
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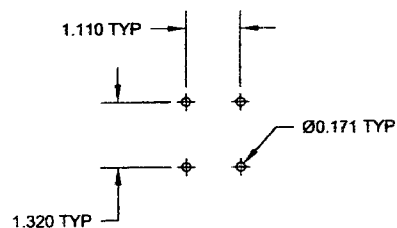
DETAIL A D6-3
SCALE 4X D4-4



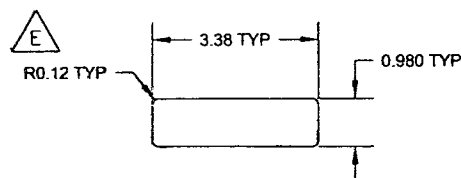
DETAIL B C6-3
SCALE 4X C6-4



DETAIL E C1-1
SCALE 4X

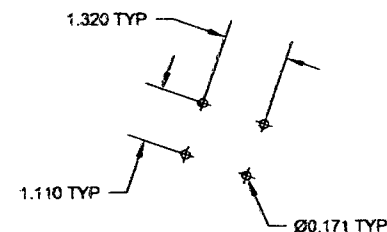


DETAIL C D7-1
SCALE 4X D3-1
D6-2
D3-2



NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D C5-1
SCALE 4X D4-1
B6-2
C2-2



DETAIL F C4-2
SCALE 4X

RELEASED
2009-09-09

116054947

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MFG. APPR.	U	D3186	SHEET 5 OF 5
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